

280/016
EP

12 **EUROPEAN PATENT APPLICATION**

21 Application number: 85305292.6

51 Int. Cl.⁴: **G 02 B 5/18**

22 Date of filing: 25.07.85

30 Priority: 08.08.84 GB 8420182

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43 Date of publication of application: 26.03.86
Bulletin 86/13

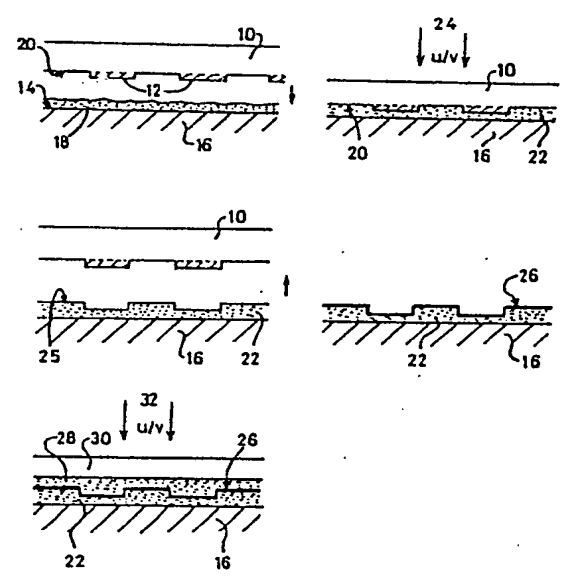
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84 Designated Contracting States: AT CH DE FR GB IT LI
NL SE

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54 **Manufacture of diffraction gratings.**

57 In a method of manufacturing a diffraction grating, the grating-bearing surface (20) of a master grating (10) is coated with a release agent, and a rigid substrate (16) has a layer of ultraviolet sensitive liquid resin (18) applied thereto before bringing the master grating and the substrate together to trap a film (22) of the liquid resin therebetween, whereafter the liquid resin is cured by exposure to ultraviolet light (24) through the master grating and the master grating and resin-profiled substrate are separated prior to completion of the diffraction grating by deposition of a thin metal film (26) on the resin-profiled surface of the substrate.



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Title: Manufacture of Diffraction GratingsField of the Invention

This invention relates to a method of manufacture of a diffraction grating for application in metrology. More especially, for example, the diffraction grating produced by method of this invention finds application in the
5 displacement measuring apparatus and method of the Applicant's European Patent Specification No 0132978.

Object of the Invention

It is an object of the invention to enable reproduction of replica gratings from a master grating, in particular a master grating of glass or analogous light-transmitting
10 material wherein the grating is formed either by a pattern in relief on one surface of the glass master or by a pattern of deposited metal, more especially chromium, on the one surface of the glass master.

The Invention

According to the invention, a method of manufacturing a
15 diffraction grating comprises:-

- 1) coating the grating-bearing surface of a light transmitting master grating with a release agent;
- 2) applying ultraviolet sensitive liquid resin to a rigid substrate and bringing the master grating and the
20 substrate together to trap a film of liquid resin between

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the substrate and the grating-bearing surface;

3) curing the resin film by exposure thereof to ultra-violet light transmitted through the master grating;

5 4) separating the master grating and the resin-profiled substrate at the grating-bearing surface of the master grating coated with release agent;

5) depositing a thin metal film on to the resin-profiled surface of the substrate, as by sputtering or
10 evaporation.

A preferred method includes the following further steps:-

6) coating the deposited metal film on the substrate with liquid ultra violet-sensitive resin;

7) covering the resin coating with a light-
15 transmitting strip or plate to smooth the surface of said resin coating and exposing the resin coating to ultra-violet light through the light-transmitting strip or plate in order to cure the resin;

8) separating the light-transmitting strip or plate
20 from the replica diffraction grating constituted by the treated substrate.

The substrate itself is preferably of metal, for example steel, which is preferably surface roughened before application of the liquid resin in step 2). This
25 roughening may be effected by fine grinding or by sand blasting. The deposited metal film can be aluminium, but other metal depositions may be preferred for improved environmental performance.

The entire process is desirably carried out at normal
30 ambient temperature, whereby stress levels in the cured resin are minimised and highly accurate replica gratings are achieved.

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The invention also extends to diffraction gratings produced by the above described method.

Description of drawings

In the accompanying drawings:-

Figures 1A to 1E show steps of a preferred grating manufacturing method in accordance with the invention; and Figure 2 shows a final grating.

Description of method

In Figure 1A, a master diffraction grating 10 is of glass with a grating pattern 12 formed by chromium deposited on the glass. The invention enables the production of replica gratings from the master 10.

For this purpose, the final step in the method is to roughen the surface 14 of a steel substrate 16, as by fine grinding or sand blasting, and applying thereto, as by a doctor blade, a layer of liquid polymer resin 18 of the type curable by exposure to ultra violet light.

The grating-bearing surface 20 of the master 10 is coated with a release agent and the master and the substrate 16 are then brought together, as shown in Figure 1B, to trap a film 22 of resin between the substrate and the grating-bearing surface. The resin 22 is then cured by exposure to ultra violet light transmitted through the master 10, as indicated at 24. This step may be accomplished by passing the master/substrate assembly beneath a high intensity ultra violet source. The chromium pattern 12 on the master 10 does not prevent the liquid resin underneath said pattern from being cured, since scattering of light takes

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place emanating from the light transmitting regions or gaps between the lines of the chromium pattern.

At the next step, Figure 1C, the master 10 coated with release agent is separated from the profiled, cured resin 5 film 22 on the substrate 16. It is found that the replica has an accurately controlled profile 25 substantially independent of process variables. For minimising stress in the cured resin, all the above and following stages of the method are desirably carried out at normal ambient 10 temperature. This ensures dimensional stability.

At the next step shown in Figure 1D, a thin metal film 26 is deposited on the profiled resin film 22, as by sputtering or evaporation. Aluminium is one suitable metal to form the deposition.

15 Referring to Figure 1E, this metal film 26 is in turn covered by a layer of liquid ultra violet-sensitive polymer resin 28, smoothed by covering with a glass strip or plate 30 through which the resin layer 28 is then cured by exposure to ultra violet light as indicated at 32. 20 Finally, the replica grating is separated from the glass cover 30.

The final form of the replica grating is shown in Figure 2. Its flatness is determined by the glass master, as any irregularities in the metal are levelled by the polymer 25 resin.

The above-described method is equally applicable to replication of an all glass master diffraction grating. The method has the advantages of avoiding degradation in quality which can arise when replication is carried out

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via an intermediate former, of being simple and inexpensive, and of placing no limit on the length of the replica gratings within the dimensions of the master.

Ultra violet sensitive polymer resins afford extremely
5 good replication capability with minimum risk of underfilling the form to be copied. In practice, replica gratings have been faithfully reproduced with depths in the range from 0.1 to 0.26 microns.

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Claims

1. A method of manufacturing a diffraction grating characterised by the following steps in combination:-

- 1) coating the grating-bearing surface (20) of a light-transmitting master grating (10) with a release agent;
5
 - 2) applying ultraviolet sensitive liquid resin (18) to a rigid substrate (16) and bringing the master grating and the substrate together to trap a film (22) of liquid resin between the substrate and the grating-bearing surface;
10
 - 3) curing the resin film 22 by exposure thereof to ultra-violet light 24 transmitted through the master grating;
15
 - 4) separating the master grating and the resin-profiled substrate at the grating-bearing surface of the master grating coated with release agent;
20
 - 5) depositing a thin metal film (26) on to the resin-profiled surface (25) of the substrate, as by sputtering or evaporation.
2. A method according to claim 1, characterised by the following further steps:-
- 6) coating the deposited metal film on the substrate with liquid ultraviolet-sensitive resin (28);
 - 7) covering the resin coating with a light-transmitting strip or plate (30) to smooth the surface of
25 said resin coating and exposing the resin coating to

ultra-violet light (32) through the light-transmitting strip or plate in order to cure the resin;

8) separating the light-transmitting strip or plate from the replica diffraction grating constituted by the
5 treated substrate.

3. A method according to claim 1 or 2, characterised in that the substrate is a metal substrate such as a steel substrate.

4. A method according claim 3, characterised in that the
10 metal substrate is surface roughened, as by line grinding or blasting, before application of the liquid resin in step 2.

5. A method according to any of claims 1 to 4, characterised in that the deposited metal film is of
15 aluminium.

6. A method according to any of claims 1 to 5, characterised in that all steps are carried out at normal ambient temperatures.

7. A diffraction grating manufactured by the method of
20 any of claims 1 to 6.

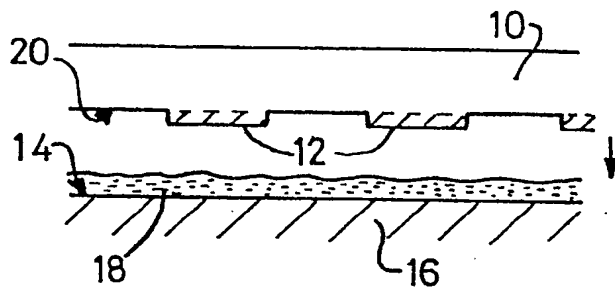


Fig. 1A

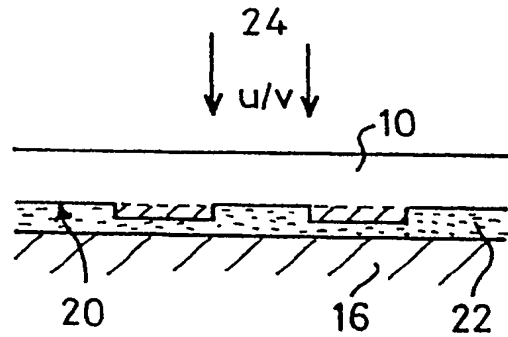


Fig. 1B

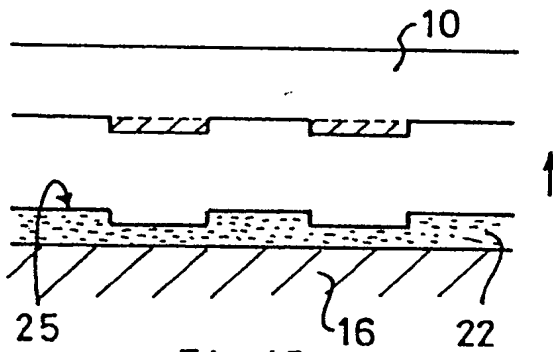


Fig. 1C

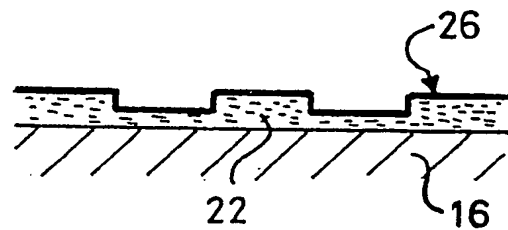


Fig. 1D

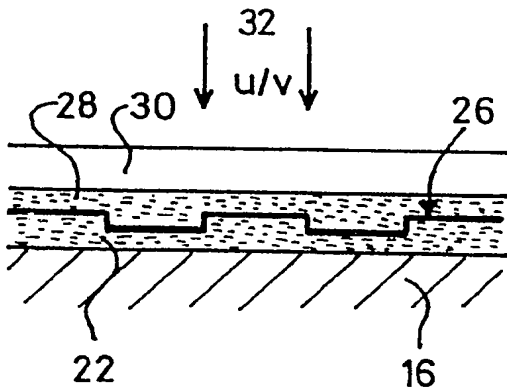


Fig. 1E

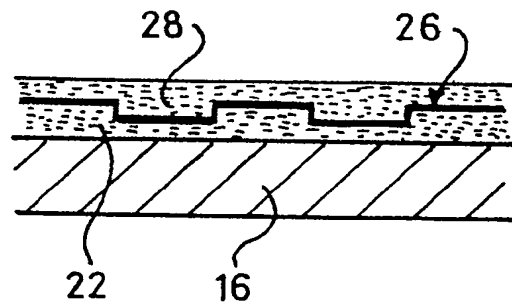


Fig. 2



European Patent
Office

EUROPEAN SEARCH REPORT

Application number

EP 85 30 5292

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
X	GB-A-2 082 343 (CANON K.K.) * page 4, lines 85-120 *	1,2	G 02 B 5/18
A	GB-A- 817 051 (NATIONAL RESEARCH) * claims 12,18 *	1,4,5	
A	DE-A-2 915 209 (N.V. PHILIPS) * page 7, page 14, third paragraph *		
A	DE-A-2 800 476 (INSTRUMENTS S.A.) * claims 1,2 *		
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			G 01 D 5/38
			G 02 B 5/18
			G 11 B 7/26
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 12-11-1985	Examiner FUCHS R
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			

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